

Wednesday, 06/08/2008 10:34:57 AM

User: Melanie Fauteux

Process Sheet

A S A P

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41009
 Estimate Number : 13542
 P.O. Number :
 This Issue : 06/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-08-06
 Comment : Est Rev:A 08-08-05 new issue DD verified by:ec

Drawing Name : 412 SKI WEARPLATE
 Part Number : D3796041
 Drawing Number : D3796 REV.A PREL
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 06/08/2008 Qty: 2 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 2.0769 sf(s)/Unit Total: 4.1538 sf(s)

NEOPRENE SHEET 0.063

batch: 108724 LB 8-8-6

Scrp.

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3796

Dwg Rev: PRE L LB 8-8-6Prog Rev: PRE L2-Deburr if necessary LB 8-8-6

(3)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

LB 8-8-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0 QC8 SECOND CHECK



Comment: SECOND CHECK



S 08/08/06 (x3)

5.0 D30093 Cup



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Cup

batch: 2 x 37489 34 34 x 40613

EL 8-8-7

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 SKI WEARPLATE

Job Number: 41009

Part Number: D3796041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hardcoat and cups as per dwg D3796

Hardcoat 2059B B# 108631

SS Tig Rod 316 LHS B# 107057

③
EZ
8-8-8

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-08(3)

8.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

STRAIGHTEN PARTS AS MUCH AS POSSIBLE PRIOR PAINTING

① ②
15-08-08-08

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08-08-15 AUTH _____

RELEASED _____ DATE _____

Powder coat grey

08/08/15 m/h

②X

QC 3

W

08-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/08/11	6.0	took 1 piece to FABRICATE JIG DT 9037	pl	08/08/11		08/08/18	08/08/18

Part No: D3796-041 PAR #: _____ Fault Category: Large Fps NCR: Yes No DQA: A Date: 08.08.21
D412-777 "Process" QA: N/C Closed: _____ Date: _____

NCR: 41009		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/18	6.0	Parts were warping during welding, causing them not to fit during installation. R.C. No jig to hold them flat	08/08/18	Made DT 90410 - Scrapped 2 pieces Qty 2 = Replace "	08-08-18	08/08/18	08/08/18	08/08/18

NOTE: Date & initial all entries